

Work Order ID 83308

83308

Page 1

Tuesday, April 17, 2012 1:12:57 PM

Item ID: D4407-3

Accept

N900040100

Setup Start *NS1*

Revision ID:

Stop *NS2*

Item Name: Bar

Start Date: 4/17/2012 Start Qty: 20.00

20

Cust Item ID:

Required Date: 4/25/2012 Req'd Qty: 20.00

20

Customer:

Reference:

Approvals:

Process Plan:

Date: 12-04-17 Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Run Start *NR1*

Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D4407	B								

100

0.00

100

Cold Saw

Memo

0.00

Hyd Mech

Cut blanks at 58.12"

12/05/17

20

110

0.00

110

HAAS 1

Memo

0.00

HAAS CNC vertical machine #1

1-Mill as per folio FB082 & dwg D4407,

FOLIO REV: AA

DWG REV: B

2-Deburr as required

12/05/21

20

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Page 2

Item ID: D4407-3 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: Bar
 Start Date: 4/17/2012 Start Qty: 20.00 ***20*** Cust Item ID:
 Required Date: 4/25/2012 Req'd Qty: 20.00 ***20*** Customer:
 Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
120 *120* QC Quality Control	QC2- Inspect parts off machine FAI/FAIB Memo	0.00 0.00		BA 12/05/21		20	0		
130 *130* QC Quality Control	QC8- Inspect parts - second check Memo	0.00 0.00		OK 12/05/22		20	0		
140 *140* Packaging Packaging	Identify as per dwg & Stock Location: <u>U/A</u> Memo	0.00 0.00				X 20		MAL 12/05/22	

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Work Order ID 83308***83308***

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Cust Item ID:

Required Date: 4/25/2012 Req'd Qty: 20.00

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Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start ***NR1***

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

150

QC21- Final Inspection - Work Order Release

0.00

150

QC

Memo

0.00

Quality Control

12/5/22 *[Signature]*
ME
12-05-22

W/O:		WORK ORDER CHANGES						
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NOTE: Date & initial all entries

Picklist Print

Tuesday, April 17, 2012 1:13:01 PM

Page 1

Work Order ID: 83308

83308

Parent Item: D4407-3

D4407-3

Parent Item Name: Bar

Start Date: 4/17/2012

Required Date: 4/25/2012

Start Qty: 20.00

Required Qty: 20.00

Comments: IPP revA 11.06.06 new issue EC verified by:DD
12/02/13 new issue JFS verified by:JLM

IPP revB

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
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M304B0.250x0.500

Purchased

No

100

f

142.0800

4.843

101.9579

M304B0 250x0 500

**

304 BAR .250 x .500

Location

Loc Qty

Loc Code

MAT050

142.08

121216

142.08

M 121547 X120

941210517

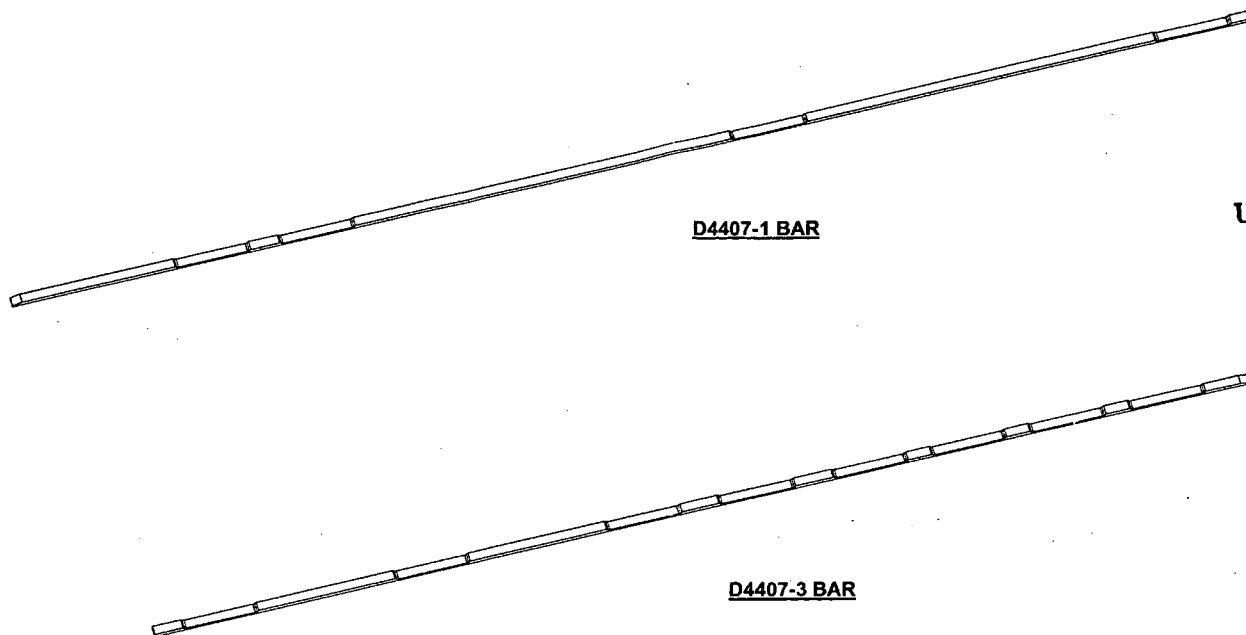
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NOTE: Date & initial all entries



SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 83388

R12-09-17

RELEASED
2012-02-23
MP

B	REMOVE TOOLING HOLES FOR -1/3; RE-DESIGN D4407-3	RF	12.01.30
A	NEW ISSUE	RF	11.08.15
REV.	DESCRIPTION		BY DATE
DESIGN	RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	RF		
CHECKED	<i>[Signature]</i>	DRAWING NO. D4407	REV. B SHEET 1 OF 3
MFG. APPR.	<i>[Signature]</i>	TITLE BAR	SCALE NTS
APPROVED	<i>[Signature]</i>	COPYRIGHT © 2011 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	
DE APPR.	<i>[Signature]</i>		
DATE	12.01.30		

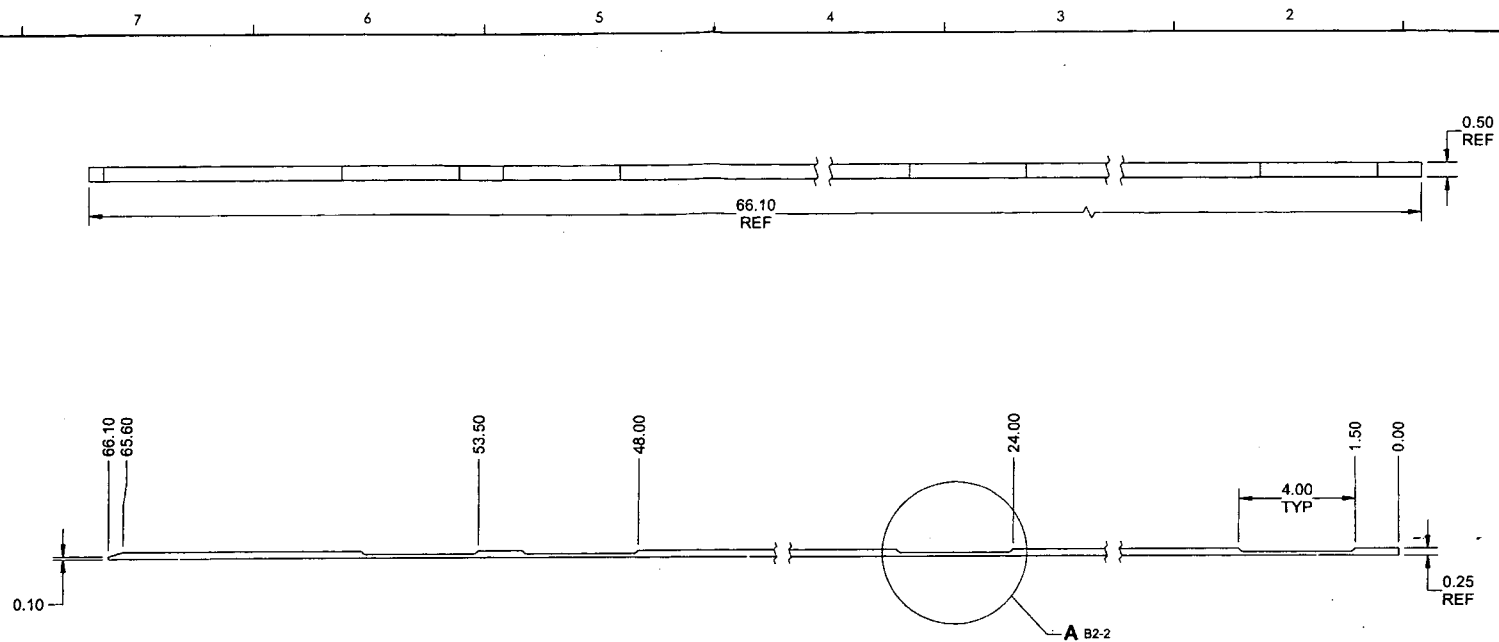
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D4407-1 BAR

DETAIL A C3-2
TYP, SCALE 2X

RELEASED
2012-06-05

NOTES:

- 1) MATERIAL: AISI 304/316 STAINLESS STEEL, 0.250 x 0.500 BAR
PER ASTM A276 OR ASTM 240
REF. DART SPEC. M304B
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: = 2.11 lbs

DESIGN	RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	RF		
CHECKED	RF	DRAWING NO. D4407	REV. B
MFG. APPR.	RF	SHEET 2 OF 3	
APPROVED	RF	TITLE	SCALE
DE APPR.	RF	BAR	NTS
DATE	12.01.30	<small>COPYRIGHT © 2011 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.</small>	

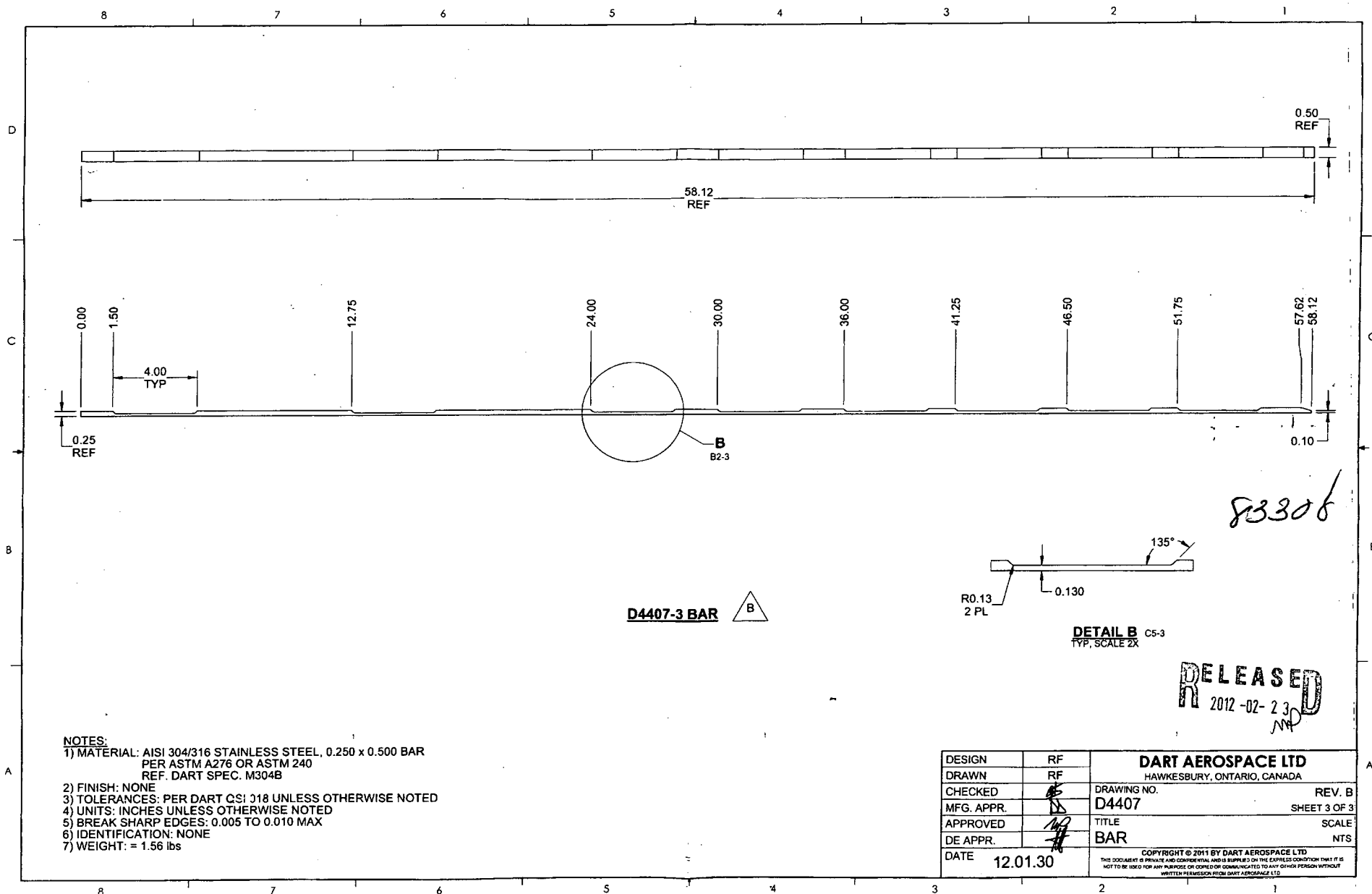
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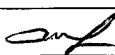
NOTE: Date & initial all entries

DART AEROSPACE LTD	Work Order: 83308
Description: BAR	Part Number: D4407-3
Inspection Dwg: D4407 Rev: B	Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
1.50	+/- .030	1.50	✓		Vern	GA-01
4.00	+/- .030	4.00	✓		"	"
12.75	+/- .030	12.75	✓		Tape	GA-12
24.00	+/- .030	24.00	✓		"	"
30.00	+/- .030	30.00	✓		"	"
36.00	+/- .030	36.00	✓		"	"
41.25	+/- .030	41.25	✓		"	"
46.50	+/- .030	46.5	✓		"	"
51.75	+/- .030	51.75	✓		"	"
57.62	+/- .030	57.75	✓		"	"
58.12	+/- .030	58.12	✓		"	"
0.10	+/- .030	0.095	✓		Vern	GA-01
0.130	+/- .010	0.135	✓		"	"
135°	+/- 1/2°	135°	✓		Angle Meter	CNC-03

Measured by: GA	Audited by: 	Prototype Approval:	N/A
Date: 12/05/21	Date: 12/05/22	Date:	N/A

Rev	Date	Change	Revised by	Approved
A		New Issue	KJ/JLM	